

# Work Order ID 82153

Friday, March 23, 2012 1:25:20 PM

**\*82153\***

Page 1

Item ID: D3535-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearshoe  
 Start Date: 3/23/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 3/30/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev <b>B</b>

100

0.00

**\*100\***

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: **B** Prog Rev: **B** 2-  
 Deburr if necessary

**304 ,040**

**B/JM** **120404** **(20)**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

**B/Jm.** **120404** **(20)**

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

**Sizkulos**

**counts**  
**(120)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82153

**\*82153\***

Page 2

Friday, March 23, 2012 1:25:20 PM

Item ID: D3535-11 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearshoe  
 Start Date: 3/23/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 3/30/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC	NC BRAKE	0.00							
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT83262-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-11	0.00							
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 <b>*150*</b> Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 11:45 FINISH TIME: 12:15	0.00							

SB 12/04/09 (20)  
 carb  
 (T20)

20x ✓ m.k  
 12/04/10

m 117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 82153**

Friday, March 23, 2012 1:25:20 PM

**\*82153\***

Page 3

Item ID: D3535-11

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Wearshoe

Start Date: 3/23/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

20 ~~0~~ *BL 12-4-10*

170

Identify as per dwg & Stock Location: *F-P 1* 0.00**\*170\***

Packaging

Memo

0.00

Packaging

20 X *m-k 12/04/10*

180

QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC

Memo

0.00

Quality Control

*12/4/12*  
*12-04-10*

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, March 23, 2012 1:25:26 PM

Page 1

Work Order ID: 82153

**\*82153\***

Parent Item: D3535-11

**\*D3535-11\***

Parent Item Name: Wearshoe

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	161.1609	0.7015	14.76842	14.		

**\*M304S20GA\***

**\*\***

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	161.160922	
116623	0.2	
117933	27.3442	
118400	21.1723	
118964	36.5	
119346	29.8	
120604	46.144422	

120604 B/jm 120404

20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82153
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-11
<b>Inspection Dwg:</b> D3535	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.010	5.00	✓		Vern	HB-02
8.00	+/-0.010	8.02	✓		Vern	HB-02
14.00	+/-0.010	14.00	✓		MT	HB-01
21.150	+/-0.010	21.150	✓		MT	HB-01
26.650	+/-0.010	26.650	✓		MT	HB-01
5.650	+/-0.010	5.645	✓		Vern	HB-02
Ø0.188	+0.005/-0.001	1.90	✓		Vern	HB-02
0.300	+/-0.010	0.303	✓		Vern	HB-02
0.300	+/-0.010	0.302	✓		Vern	HB-02
0.038	+/-0.010	0.035	✓		Vern	HB-02

<b>Measured by:</b> JS/JM	<b>Audited by:</b> JS	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/04/04	<b>Date:</b> 12/04/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/DD	JS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

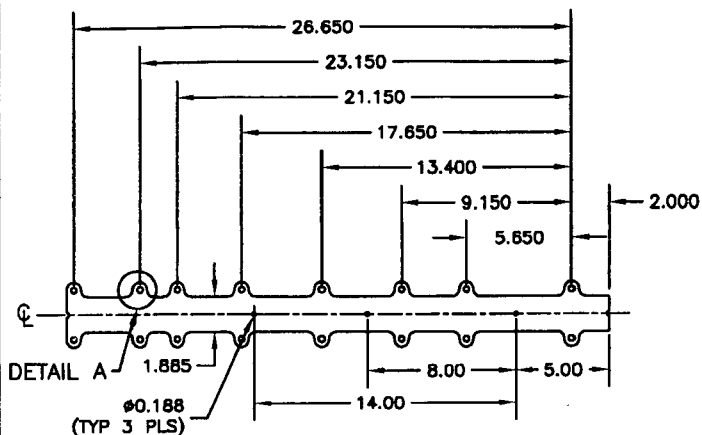
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**DART**

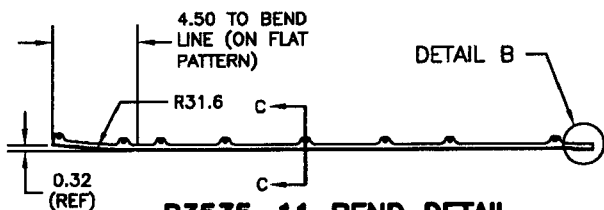
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07.04.24

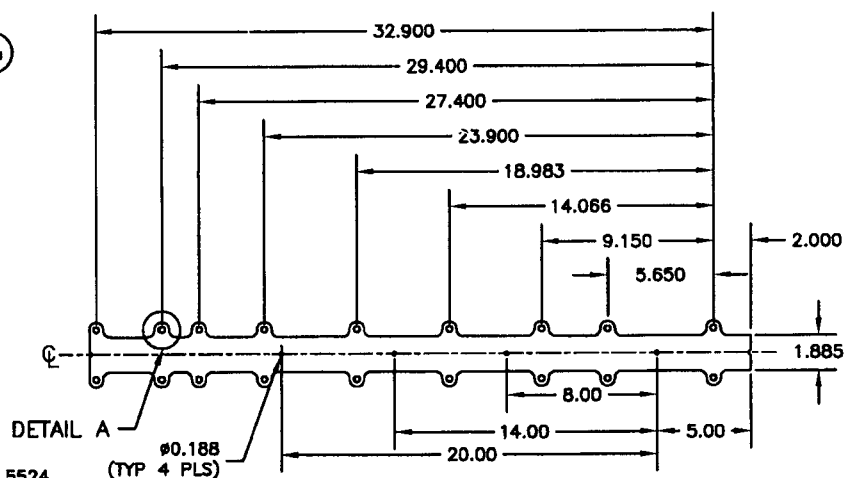
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82153  
1012-03-23



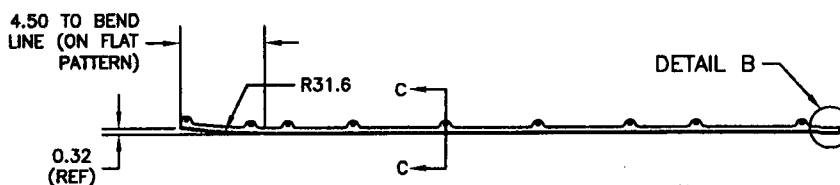
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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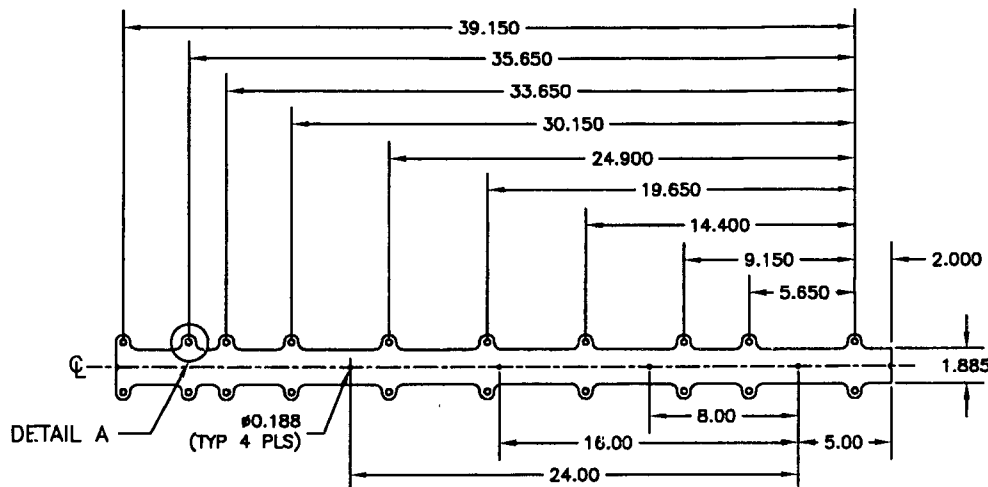
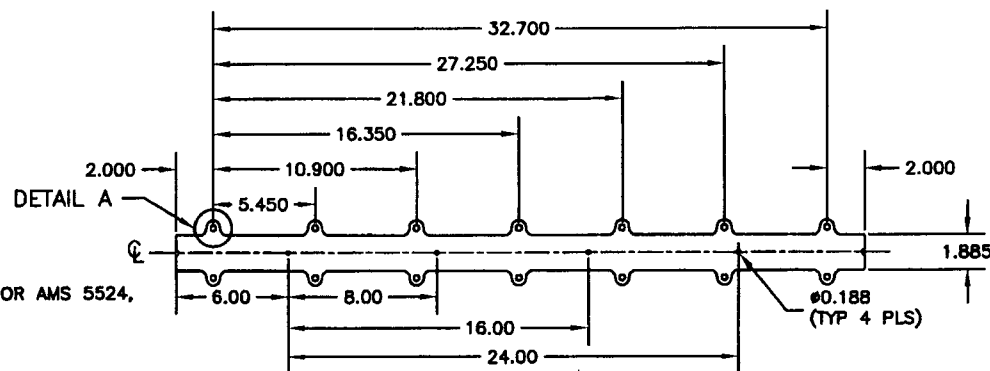
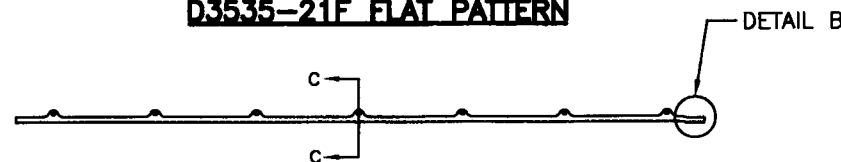
**NOTE:** Date & initial all entries

**DART**

RELEASED

07.04.24

82153

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 2 OF 7
		SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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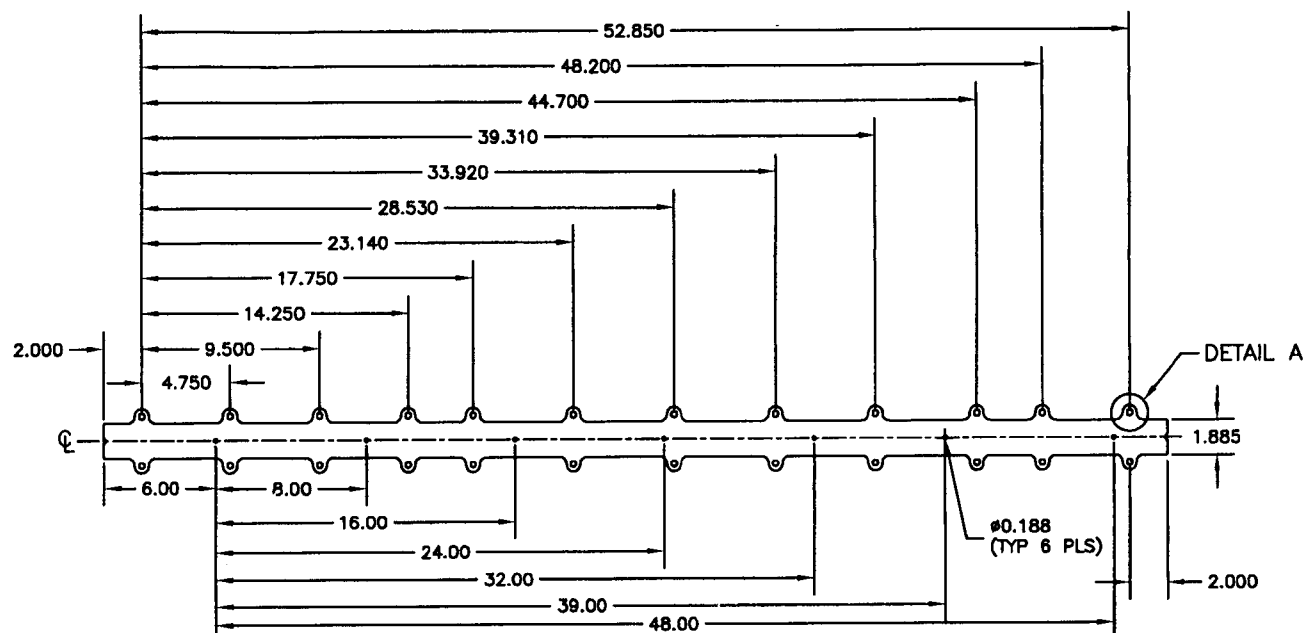
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07.04.24

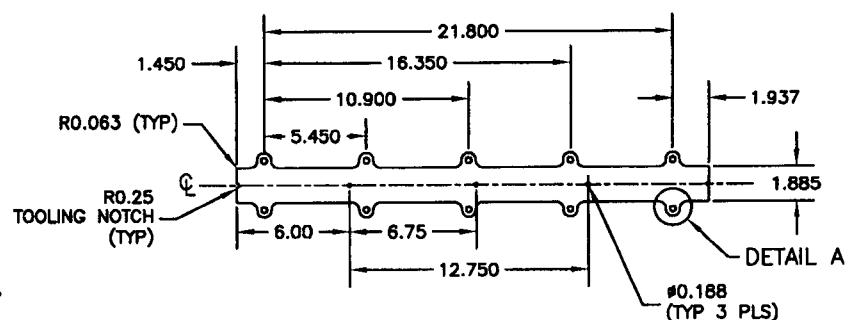
82153

DESIGN	C.B.	DRAWN BY	A.H.	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



**D3535-23F FLAT PATTERN**

**D3535-23 BEND DETAIL**



**D3535-25F FLAT PATTERN**

**D3535-25 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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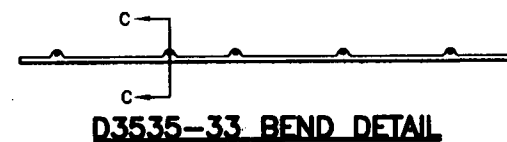
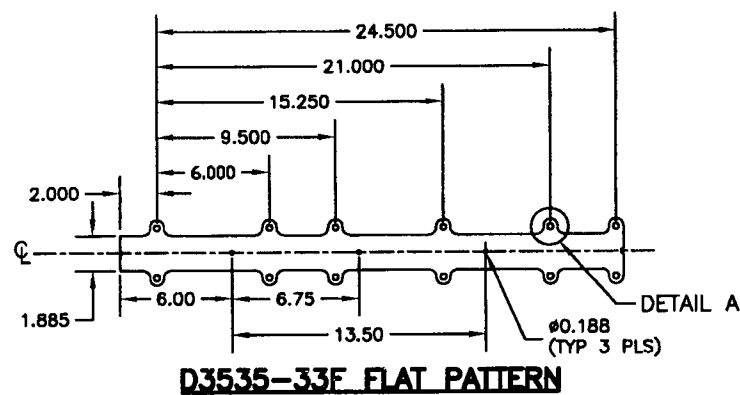
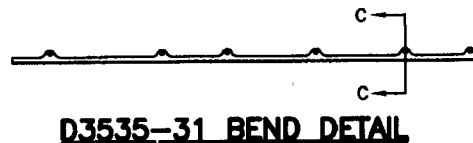
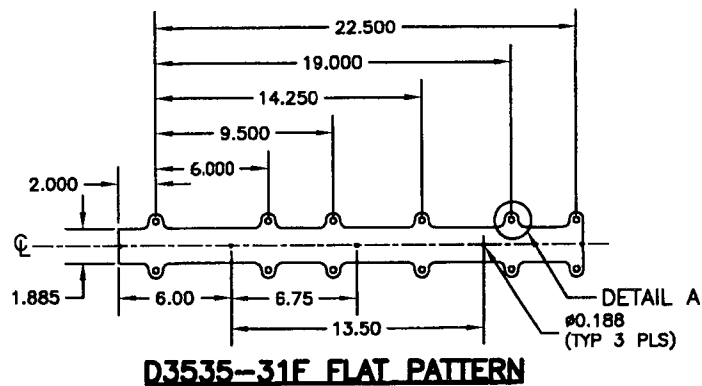


**DART**

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07.04.24

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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\bar{C}$
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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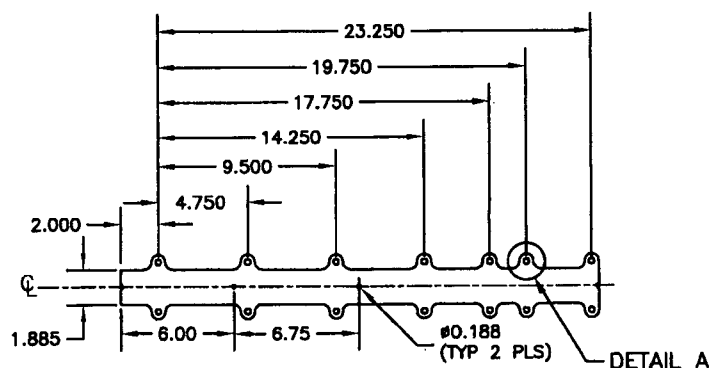
**NOTE:** Date & initial all entries



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07.04.17

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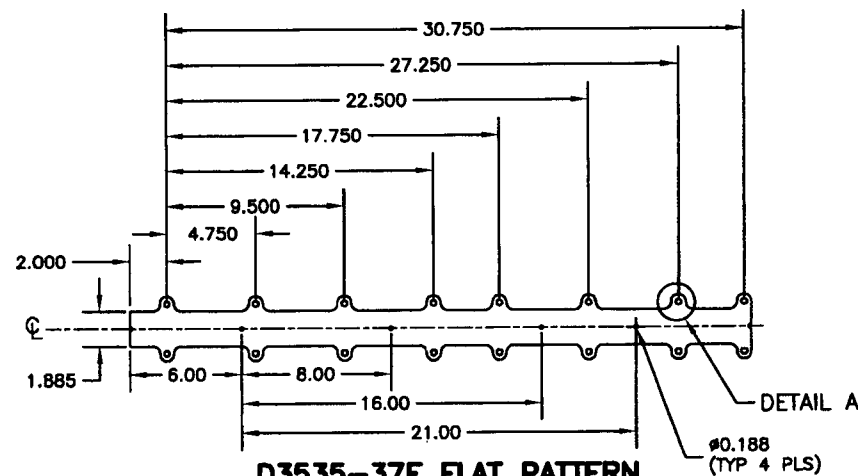
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>	REV. B
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SHEET 5 OF 7	SCALE <b>1:10</b>



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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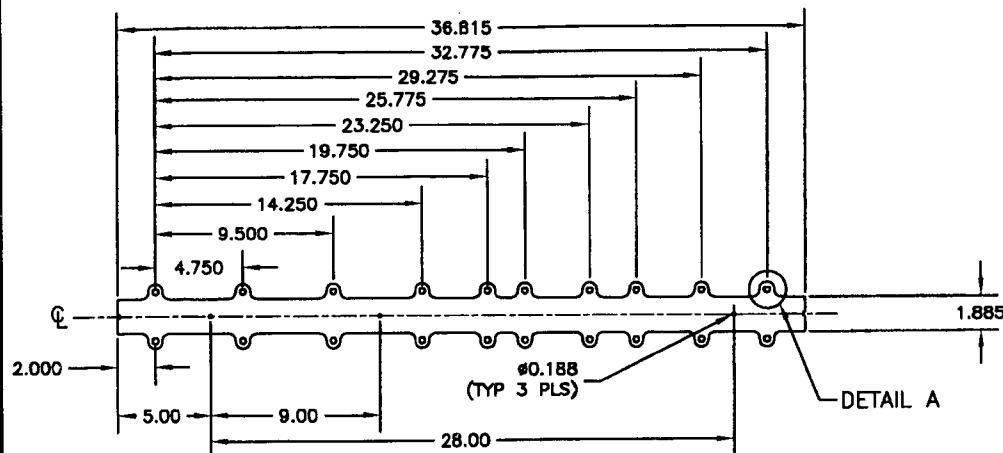
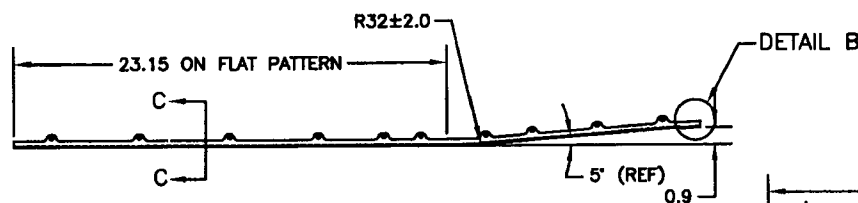
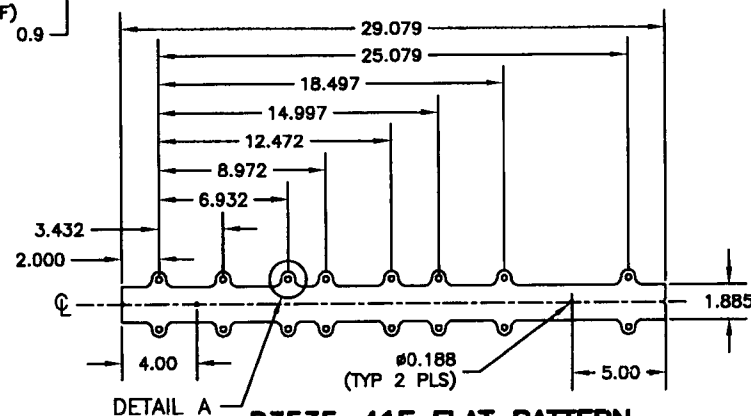
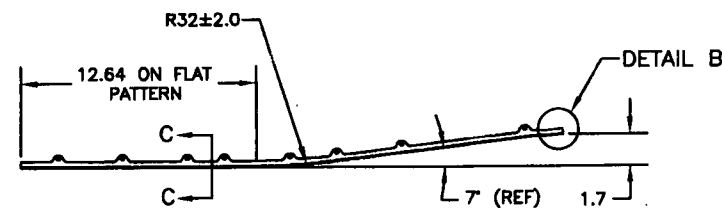
**DART**

RELEASED

07.04.17

82153

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 6 OF 7
	SCALE <b>1:10</b>	

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

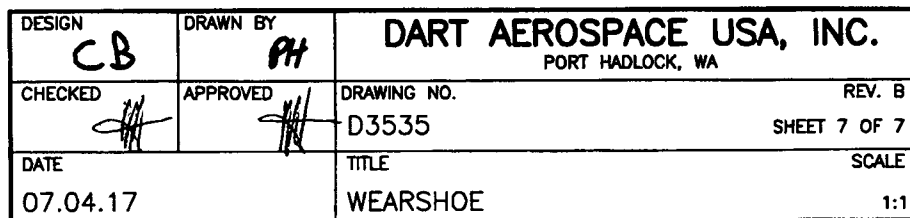
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

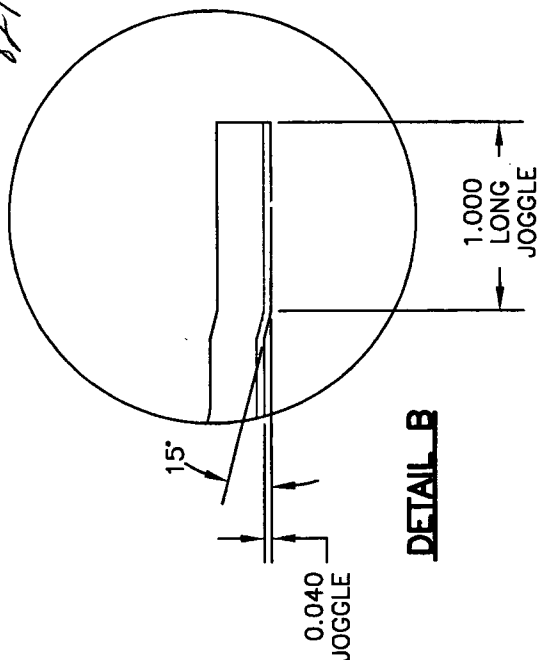
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

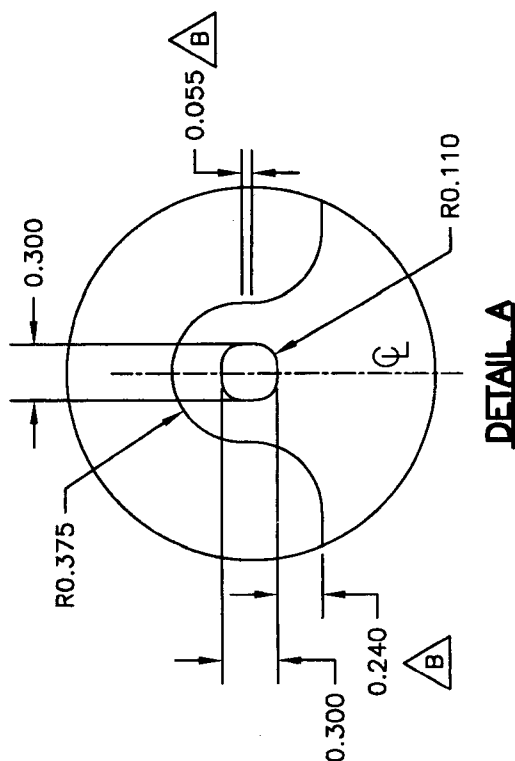


07.04.24

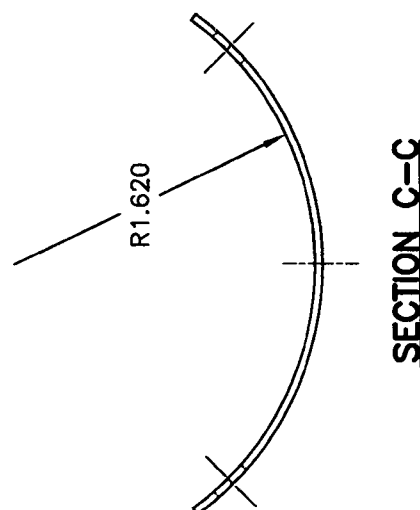
82/53



## DETAIL B



## DETAIL A



## SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries